

Date: Monday, 6/26/2006 2:39:12 PM  
 User: Brenda Leonard

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SPACER
<b>Job Number</b> :	27666		
<b>Estimate Number</b> :	10383		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D30661
<b>This Issue</b> :	6/26/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3066 REV. A
<b>First Issue</b> :	6/26/2006	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27526	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	N/A
		<b>Due Date</b> :	6/30/2006
<b>Written By</b> :	<u>SEE COMMENT BELOW</u>		<b>Qty:</b> 50 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0992 sf(s)/Unit Total: 4.9613 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: M101178

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: AProg Rev: A

2-Deburr if necessary

M.F. 06-07-06.

SAP 06:06:27

50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 06:06:27

50

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06-06-28 50

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Date: Monday, 6/26/2006 2:39:12 PM  
User: Brenda Leonard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27666

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-07-08

50

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06-07-10

50

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

06-07-10 (50)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-10

Job Completion



U 06-07-10

Date: 6/23/2006 7:33AM  
User: Kim Johnston

## PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job No.	: 27666	Part No.	: D30661
Estimate No.	: 10383	Drawing No.	: D3066 REV. A/B
P.O. No.	: <u>                    </u> SO No. <u>                    </u>	Drawing Rev.	: A/B
First Issue	: / /	Project No.	: N/A
Prsht Rev.	: NC	Material	: <u>                    </u>
This Issue	: 6/23/2006	Due Date	: 6/30/2006
Prev. Run	: 27526	QTY:	: 50
Type : MACHINED PARTS			

Written by:

Checked & Approved by:

Comment :

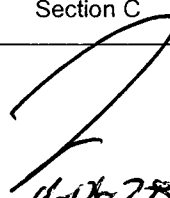
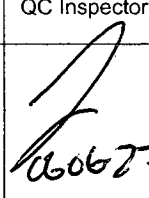
Est:                      02.11.01 Incorporated D3066-1 IPP KJ/RF

Job Number:



Seq. No.	Machine or Operation	Description
1.0	M6061T6S080	6061-T6 .080 Sheet
	Comment: Qty.: 0.0992 sf(s)/Unit Total : 4.9613 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>                    </u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: <u>                    </u> Prog Rev: <u>                    </u> 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.06.27	20	Tip was too large on the machine, causing 0.128 to be oversized.	CP 06.07.10 per 06.042	Change tip: scrap! replace parts. Qty 5	06.06.28 SAN	 06.06.28	CP 06.07.10 per 05.042	 06.06.27

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Job Number:



Seq. No.	Machine or Operation	Description
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT CHEMICAL CONVERSION COAT	
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:	
9.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

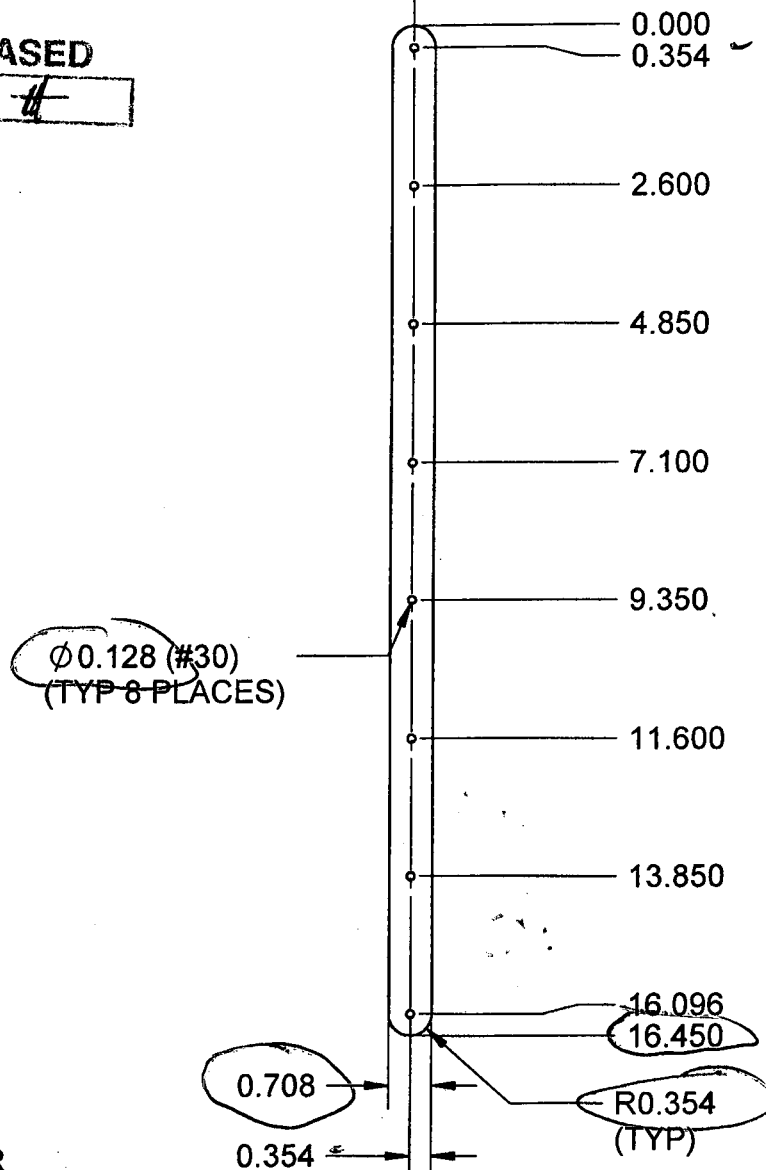
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3066</b>	REV. B SHEET 1 OF 1
DATE <b>06.05.29</b>		TITLE <b>SPACER</b>	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED***de. de. 20***D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

TOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *27666*

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DART AEROSPACE LTD		Work Order:	27666
Description:		Part Number:	D3066-1
Inspection Dwg: , Rev:		Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

## Prototype

[illegible]

Measured by: <i>SAD</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>N/A</i>
Date: <i>06/06/22</i>	Date: <i>06/06/22</i>	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	